

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: 2017-12 Date Opened: 13 January 2017 Title: AssemblyAircraft OEM: Eurocopter Aircraft Model: AS350 Product Type: Bicycle Rack Product Model: Cam Levers Quantity: 50 LH/ 50 RH**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification  
Time Sheet (R&D)  
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
JC
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JC
N/A

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
100222	0	Cam Fabrication	JC

**Traveller**

Initial or N/A


**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

47/47
N/A
N/A
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

N/A
JC
<i>JC</i> N/A <i>JC</i>
N/A
JC

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: D. Martyn

Sign: *[Signature]*

SCA: AD05

Date: 18-Jul-17

ICC / Dual Inspection performed by:

Print: N/A - JC

Sign: *[Signature]*

SCA:

Date:

Work Order closed by:

Print: J. Clarke

Sign: *[Signature]*

SCA: AD02

Date: 18-Mar-19

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: 2017-12 Date Opened: 13 January 2017 Title: AssemblyAircraft OEM: Eurocopter Aircraft Model: AS350 Product Type: Bicycle Rack Product Model: Cam Levers Quantity: 50 LH/ 50 RH**Work Order Contents**

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Time Sheet (R&D)  
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
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Dual Inspections Initialled

Initial or N/A

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N/A

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
100222	0	Cam Fabrication	JC

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Initial or N/A


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Quantity Complete on This Work Order  
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As Instructed

47/47
N/A
N/A
N/A

**Certification**

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Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

N/A
JC
<del>N/A</del>
N/A
JC

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: D. MartynSign: [Signature]SCA: AD05Date: 18-Jul-17

ICC / Dual Inspection performed by:

Print: N/A - JCSign: [Signature]SCA: Date: 

Work Order closed by:

Print: J. ClarkeSign: [Signature]SCA: AD02Date: 18-Mar-19

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

**Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bushing No. of pieces: 99  
Manufacturer: Aero Design Ltd.  
Part No.: 100222-23 Serial/Batch No.: 13028  
TTSN: NA TSO: NA Rem.: NA  
Work Order No.: 2017-12  
Remaining Tasks to be Performed: weld to handle.

Signature: [Signature]  
Date: Feb 8 / 2017 Lic. No. / SCA AD-05

**In Process**



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

### **Remarks**

**In Process**

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bushing No. of pieces: 20

Manufacturer: Aero Design

Part No.: 100222-23 Serial/Batch No.: 13028

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-86

Remaining Tasks to be Performed: weld to handle

Signature: David Dineen AD  
73-04

Date: June 14/2016 Lic. No. / SCA 05

In Process





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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**In Process**

**Remarks**

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Handle R/H No. of pieces: 50

Manufacturer: Aero Design Ltd.

Part No.: 100222-22 Serial/Batch No.: 11101

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-12

Remaining Tasks to be Performed: Weld in place

Signature: David Mart

Date: Feb 8/2017 Lic. No. / SCA AD-05

In Process



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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

**In Process**

**Remarks**

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Handle cap No. of pieces: 100  
Manufacturer: Aero Design Ltd.  
Part No.: 100222-24 Serial/Batch No.: 3021  
TTSN: NA TSO: NA Rem.: NA  
Work Order No.: 2017-12  
Remaining Tasks to be Performed: Weld to handle.

Signature: David Mack

Date: Feb 8 / 2017

Lic. No. / SCA AD-05

In Process



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9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**In Process**

**Remarks**

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## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Drive Plate Assy. No. of pieces: 26 / RH

Manufacturer: Aero Design Ltd.

Part No.: 100222-0212 PC Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-12

Remaining Tasks to be Performed: Install

Signature: [Signature]

Date: July 18 / 2017 Lic. No. / SCA AD-05



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

### **Remarks**

**Serviceable**

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BICYCLE RACK HANDLE ASSEMBLY – 100222-21/22

Work Order: 2017-12

Batch Quantity: 94

Complete  
(initial or SCA #)

Date Open: 13 JAN 2017

General

These instructions apply to fabrication of components for AS350/AS355 bicycle racks. Refer to the following drawings, at the current revision, for dimensions and details:

100222, Revision 0 – Cam Fabrication

1. Prepare Stock

- a. Cut 0.5 x 0.035 square 304 stainless steel tube for handle 100222-21 / -22.
- b. Record material PO:
- c. Shear 0.025 304 stainless steel sheet for cap 100222-24.
- d. Record material PO:
- e. Deburr parts.
- f. Tag in-process parts.

AD  
73-04  
02

11101

3021

AD  
73-04  
02

2. Machine handle

- a. On manual mill, cut 7/16" diameter slot for bushing. Refer to drawing. Ensure correct orientation for right or left parts.
- b. Tag in-process parts.

3. Welding:

- a. Using fixture to set orientation, weld bushing 100222-23 into end of handle using ER308L TIG rod.
- b. Record Bushing WO:
- c. Using ER308L TIG rod, weld cap to opposite end of tube.
- d. Record TIG rod PO:
- e. Clean up welds.
- f. Tag completed parts.

2017-12

14028

AD  
73-04  
05



BICYCLE RACK DRIVE PLATE ASSEMBLY – 100222-11/12

Work Order: 2017-12

Batch Quantity: 94

**Complete**  
(initial or SCA #)

Date Open: 13 Jan 2017

*General*

These instructions apply to fabrication of components for AS350/AS355 bicycle racks. Refer to the following drawings, at the current revision, for dimensions and details:

100222, Revision 0 – Cam Fabrication

AD  
73-04  
05

1. Welding

- a. Place 100222-21 / -22 Handle in fixture and set 100222-13 Drive Plate over bushing on handle. Using ER308L TIG rod, weld Drive Plate to Handle in 2 places as indicated.
- b. Record material PO:
  - i. 100222-13 Drive Plate: 17008
  - ii. 100222-21 LH Handle: 11101
  - iii. 100222-22 RH Handle: 11101
  - iv. 308L TIG rod: 14028
- c. Tag completed parts.

## Aero Design

### Parts Distribution Sheet

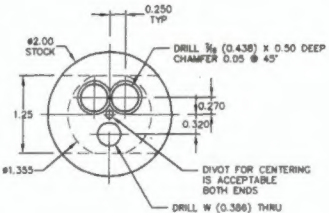
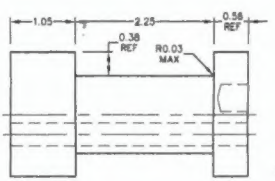
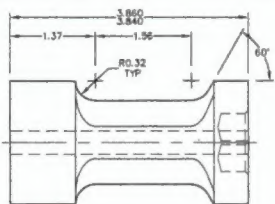
# Bike Rack Cam Handle Parts

WO# 2017-12

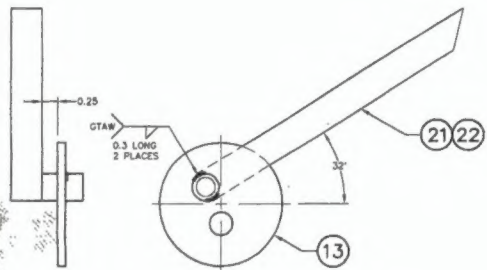
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2017-12

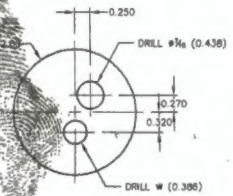
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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



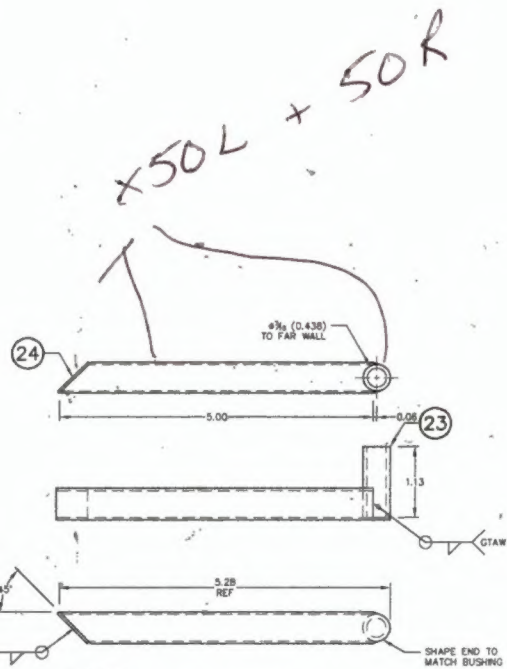
03 CAM



11/12 DRIVE PLATE ASSEMBLY  
LH SHOWN, RH OPPOSITE



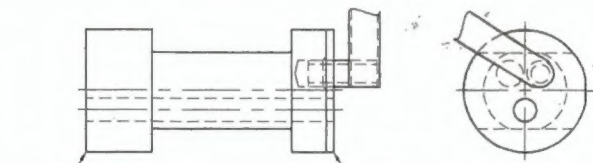
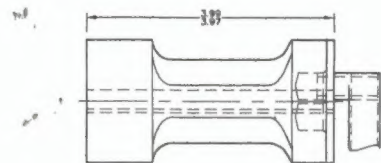
13 DRIVE PLATE



21/22 HANDLE ASSEMBLY  
LH SHOWN, RH OPPOSITE


NOTES

- 1 REMOVE ALL BURRS AND BREAK SHARP EDGES.
- 2 WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2885C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.



01/02 CAM ASSEMBLY  
LH SHOWN, RH OPPOSITE

QTY	QTY	QTY	QTY	QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	1					100222-24	24	CAP	304 STAINLESS STEEL	AMS 5613	MIN 0.025 SHEET
1	1					100222-23	23	BUSHING	304 STAINLESS STEEL	ASTM A286	0.438 X 0.065 TUBE
		1				100222-22	22	RH HANDLE ASSEMBLY	304 STAINLESS STEEL	ASTM A554	0.5 X 0.035 SGR TUBE
		1				100222-21	21	LH HANDLE ASSEMBLY	304 STAINLESS STEEL	ASTM A554	0.5 X 0.035 SGR TUBE
			1			100222-13	13	DRIVE PLATE	304 STAINLESS STEEL	AMS 5613	0.125 SHEET
			1			100222-12	12	RH DRIVE PLATE ASSEMBLY			
			1			100222-11	11	LH DRIVE PLATE ASSEMBLY			
				1	1	100222-03	03	CAM	BLACK ACETAL	ASTM D6778	2.0 ROD
						100222-02	02	RH CAM ASSEMBLY			
						100222-01	01	LH CAM ASSEMBLY			

APPROVALS		DATE		AERO DESIGN LTD.	
DRAWN: JEFF CLARKE		29 JUNE 2016		9088A MALASPINA ROAD POWELL RIVER, BC, CANADA - V8A 0G3 TEL: 250-460-5976 <a href="http://www.aerodesign.ca">www.aerodesign.ca</a>	
CHECKED: JASON REKIVE		29 JUNE 2016		AIRBUS HELICOPTERS AS350/AS355/EC130 BICYCLE RACK INSTALLATION CAM FABRICATION	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:					
DECIMALS		ANGLES			
X.XXX ±0.010		±1/2"			
X.XX ±0.03					
X.X ±0.1					
SCALE 1 : 1			DWS. SIZE	DWS. NO.	REV.
SHEET 1 OF 1			A1	100222	0



